

161526

Thursday, May 18, 2017 8:23:49 AM

N900040100

Stop *NS2*

Stop *NS2*

60

60

Stop *NR2*

Stop *NR2*

DAS JK
33 17-5-31
9-89
17/05/29

DAS 32
33 17-5-31
9-89
17/05/29

Work Order ID 161526***161526***

Page 2

Thursday, May 18, 2017 8:23:49 AM

Item ID: D3407-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stem

Start Date: 5/17/2017 Start Qty: 60.00

60

Cust Item ID:

Required Date: 5/26/2017 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

1.20

Quality Control

60

0

DAS

44

9-89

17-05-31

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

6.00

Packaging

LOCATION: WA001

60

DAS
6
9-89

MAY 31 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.60

Quality Control

17/6/2017

DAS
21
9-89

MAY 31 2017

Picklist Print

Thursday, May 18, 2017 8:23:47 AM

Page 1

Work Order ID: 161526

161526

Parent Item: D3407-3

D3407-3

Parent Item Name: Stem

Start Date: 5/17/2017

Required Date: 5/26/2017

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A05.10.18New issueKJ/EC
IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M174R0.750

Purchased

No

100

f

38.1201

0.366

23.11579

M174R0 750

**

22/7-5-31

17-4 round bar .750

Location

Loc Qty

Loc Code

MAT

38.1201

m133265

0.0001

m135232

5.345

m136200ALU

8.775

m137341

24

8.775
16.81

DART AEROSPACE LTD		Work Order:	161526
Description: Stem		Part Number:	D3407-3
Inspection Dwg: D3407 Rev: E		Page 1 of 1	

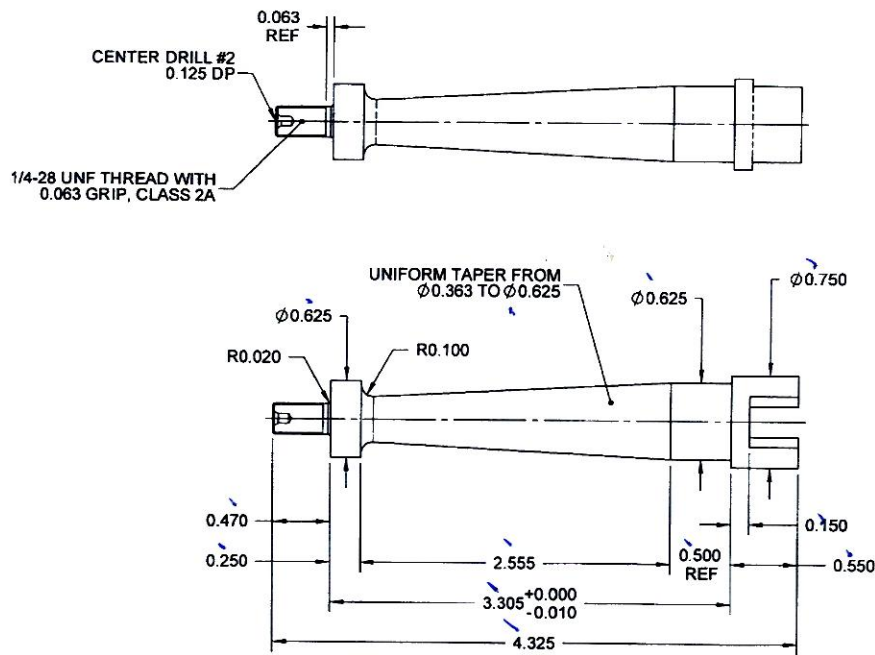
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

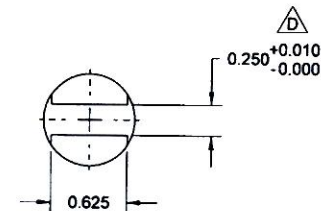
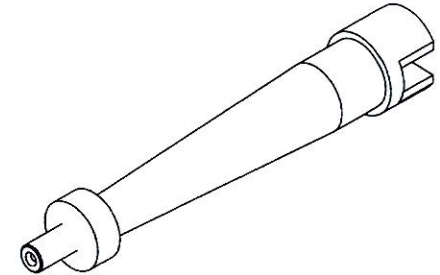
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	0,063	✓		HJD-04	vern
1/4-28 UNF	Max: 0.2668 Min: 0.2635	0,265	✓			
Major Ø	Max: 0.249 Min: 0.2425	0,246	✓			
Ø0.625	+/-0.010	0,626	✓			
Ø0.363	+/-0.010	0,364	✓			
Ø0.750	+/-0.010	0,750	✓			
R0.100	+/-0.010	0,100	✓			
0.470	+/-0.010	0,470	✓			
0.250	+/-0.010	0,249	✓			
2.555	+/-0.010	2,550	✓			
3.305	+0.000/-0.010	3,299	✓			
4.325	+/-0.010	4,325	✓			
0.150	+/-0.010	0,150	✓			
0.550	+/-0.010	0,550	✓			
0.625	+/-0.010	0,625	✓			
0.250	+0.010/-0.000	0,258	✓			

Measured by:	DAS 33 9-89	Audited by:	DAS 44 9-89	Prototype Approval:	N/A
Date:	17/05/29	Date:	17-05-31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	



D3407-3 STEM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

161526
MLJ
170517

RELEASED
08-07-23

- NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.27 lbs

DESIGN	HP	DART AEROSPACE USA, INC.
DRAWN	HP	PORT HADLOCK, WA
CHECKED		DRAWING NO. D3407
MFG. APPR.		REV. E
APPROVED		SHEET 3 OF 5
DE APPR.		TITLE TOW RING
DATE	08.07.23	SCALE NTS
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